

PRODUCT INFORMATION

ANGLER

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AccuDraw 4640

DESCRIPTION

AccuDraw 4640 is a clear, light amber colored oil, which forms a rich, white emulsion when mixed into water. Non-ionic emulsifiers are supplemented with metal deactivators to lend absolute assurance that it will not stain any metal. **AccuDraw 4640** emulsions are sweet smelling, are non-irritating to the skin of operators, and fight rancidity. These emulsions also afford fine interim rust protection for both work piece and machine. There are no silicones in **AccuDraw 4640** so parts formed with it may be painted, plated, welded or brazed without impairment.

AccuDraw 4640 performs as well as many sulfo-chlorinated heavy-duty soluble oils because of its remarkable metal wetting, high heat transfer rate and “extra oiliness” features. These translate to excellent work piece finished and prolonged die life.

APPLICATION

AccuDraw 4640 is recommended for a wide range of stamping operations on aluminum, copper and their alloys. Higher concentrations will afford protection in more difficult operations. Flood application of **AccuDraw 4640** emulsion is preferred, but emulsions also may be applied to strip or blanks by drip, roller, pad or spray. Parts are best cleaned by an immediate water wash or by an alkaline wash.

TYPICAL SPECIFICATIONS

Density, lbs/gal	7.74
Specific Gravity @60/60°F	.928
Viscosity SUS @ 100°F	318
Chlorine, % wt.	nil
Sulfur, % wt.	nil
Lubricity agent, % wt.	40
Emulsion Stability	Very Good
pH(9:1)	9.0
Flash Point, (COC) °F	320
Copper Strip Corrosion	1a

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